

Work Order ID 116359

April-14-14 7:46:05 AM

116359

Page 1

Item ID: D3189-1

Revision ID:

Item Name: Chaffing Shield

Start Date: 4/14/14 Start Qty: 20.00 ***20***

Required Date: 4/28/14 Req'd Qty: 20.00 ***20***

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MLS Date: 1404-14

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3189

D

D412-664-243

E(DEO)

100

100

Waterjet

FLOW CNC Waterjet

SHEAR

Memo

1-Cut as per Dwg

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

0.00

0.00

(20) 14/05/04 *mm/s*

103

103

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

(20) 14/05/04 *mm/s*

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Page 2

Item ID: D3189-1

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Start Date: 4/14/14

Start Qty: 20.00

20

Required Date: 4/28/14

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20

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

105

QC8- Inspect parts - second check

0.00

DAS

27

9-89

0.00

14/5/5

20

105

QC

Memo

Quality Control

110

Small Fab

0.00

110

Small Fab

Memo

Small Fab

1- Roll as per Dwg D3189

0.00

20x

14/05/07
DAS
36
9-89

120

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

0.00

14/5/8

20

120

QC

Memo

Quality Control

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Item ID: D3189-1

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Item Name: Chaffing Shield

Start Date: 4/14/14

Start Qty: 20.00

20

Required Date: 4/28/14

Req'd Qty: 20.00

20

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2Sequence ID/
Work Center ID

140

140

QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

MCS 14-05-09

AD 14-05-09

Picklist Print

April-14-14 7:46:08 AM

Page 1

Work Order ID: 116359

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Parent Item: D3189-1

D3189-1

Parent Item Name: Chaffing Shield

Start Date: 4/14/14

Required Date: 4/28/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP B05.08.22No longer made in-houseKJ/JLM
IPP Rev:C 06-03-24 Rolling Now made in House JLM
IPP Rev:D 07-04-16 As per Rev B JLM IPP Rev:E
11.05.11 now made on waterjet DD verf:JLM IPP REV:F 14.02.12
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S24GA		Purchased		No			sf	29.3000		7			

M304S24GA

304/316 .025 Sheet

**

my/D.A

Location

Loc Qty

Loc Code

MAT020

29.3

m125771

29.3

8.3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

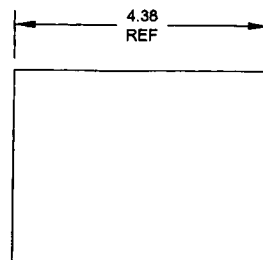
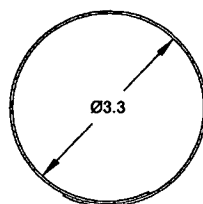
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

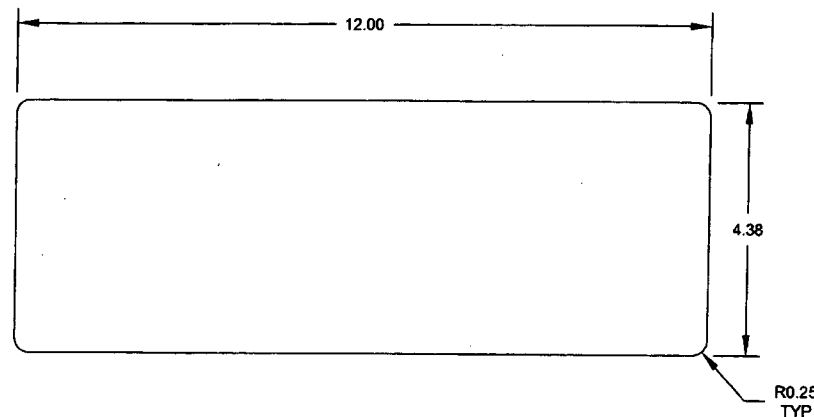
FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____



D3189-1 CHAFING SHIELD
(ROLL D3189-1F AS SHOWN)

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 24 GAUGE (0.025" THICK REF)
PER MIL-S-5059, AMS 5513, AMS 5524, ASTM A240, OR ASME SA240
REF. DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.30 lbs



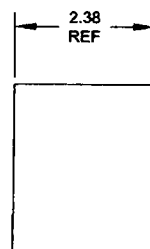
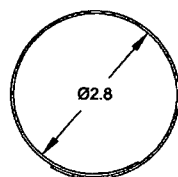
D3189-1F FLAT PATTERN

RELEASED
2014-07-10
WP

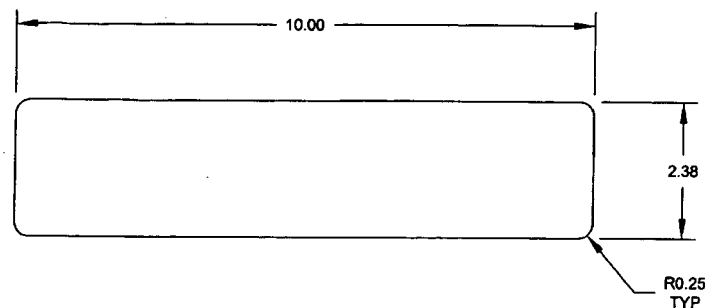
D	24GA WAS 25GA (PAR 14-328)	CP	14.01.07
C	-1/-3 ENLARGED TO REDUCE CHANCE OF DMG TO CROSSTUBE. ALL FILLETS INCREASED TO R0.25	CP	12.08.14
B	ADD -3	CP	07.01.05
A	NEW ISSUE	CP	03.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AP</i>		
DRAWN	<i>AP</i>		
CHECKED	<i>AP</i>		
MFG. APPR.	<i>AP</i>		
APPROVED	<i>AP</i>		
DE APPR.	<i>AP</i>		
DATE	14.01.07		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3189	REV. D SHEET 1 OF 2
TITLE CHAFING SHIELD	SCALE NTS
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116359-ML3
140414



D3189-3 CHAFING SHIELD
(ROLL D3189-3F AS SHOWN)



D3189-3F FLAT PATTERN

RELEASED
2014-02-10

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 24 GAUGE (0.025" THICK REF)
PER MIL-S-5059, AMS 5513, AMS 5524, ASTM A240, OR ASME SA240
REF. DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs



DESIGN	D	DART AEROSPACE LTD	
DRAWN	D	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.		D3189	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CHAFING SHIELD	NTS
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